

Date: Friday, 01/08/2008 10:42:41 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 SADDLE INBOARD, LEFT SIDE
Job Number	: 40898		
Estimate Number	: 11013		
P.O. Number	:	Part Number	: D26681
This Issue	: 01/08/2008	Drawing Number	: D2668 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: D
Previous Run	:	Material	:
Written By	:	Due Date	: 30/08/2008
Checked & Approved By	: <u>JLD 08.8.05</u>	Qty:	6 Um: Each
Comment	: Est: D 02.03.15 Added DEO 9122 NC Est Rev:D As per Rev D 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101001	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock: 7075-T7351

Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length

Batch No: B34201

J.F. 08/09/03 (6)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly.

3-Fixturing Inspection last completed on N/A by _____

4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

7- Deburr

J.F. 08/09/03 (6)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

J.F. 08/09/03 (6)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/09/03 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 10:42:41 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 SADDLE INBOARD, LEFT SIDE

Job Number: 40898

Part Number: D26681

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

24 08/09/03 (6)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1.



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

08-09-08 X6

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:15pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

1:45pm

08-09-10 X6

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD 08/09/10 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 427

8/9/11 SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/11

Job Completion



12 08-09-11

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40898
Description: 206 Saddle, Inboard, Left side		Part Number: D2668-1
Inspection Dwg: D2668 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2668 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.121"	.121"	.120"	.120"		
B	0.100	0.140		.135"	.136"	.126"	.127"		
C	1.125	1.145		1.129"	1.134"	1.134"	1.134"		
D	0.615	0.685		.663"	.663"	.663"	.663"		
E	0.240	0.260		.258"	.251"	.252"	.252"		
F	1.313	1.343		1.323"	1.323"	1.323"	1.323"		
G	0.210	0.220		.221"	.221"	.221"	.221"		
H	0.100	0.180		.140"	.140"	.140"	.140"		
I	2.470	2.510		2.494"	2.494"	2.494"	2.494"		
J	1.565	1.585		1.569"	1.574"	1.574"	1.574"		
K	0.235	0.240		.237"	.237"	.238"	.238"		
L	0.100	0.120		.110"	.110"	.110"	.110"		
M	0.990	1.010		.990"	1.001"	1.001"	1.001"		
N	0.510	0.515		.510"	.510"	.510"	.510"		
O	5.990	6.010		6.002"	6.002"	6.002"	6.002"		
P	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
Q	2.495	2.505		2.502"	2.502"	2.502"	2.502"		
R	0.313	0.318		Ø.314"	Ø.314"	Ø.314"	Ø.314"		
S	0.315	0.322		Ø.320"	Ø.320"	Ø.320"	Ø.320"		
T	1.995	2.005		2.001"	2.001"	2.001"	2.001"		
U	1.357	1.367		1.364"	1.364"	1.364"	1.364"		
V	0.787	0.807		.802"	.802"	.802"	.800"		
W	1.040	1.060		1.047"	1.050"	1.049"	1.048"		
X	1.674	1.684		1.681"	1.681"	1.681"	1.681"		
Y	0.257	0.262		Ø.258"	Ø.258"	Ø.258"	Ø.258"		
Z	0.912	0.932		.922"	.924"	.922"	.921"		
AA	0.490	0.510		.503"	.506"	.501"	.502"		
AB	0.178	0.198		R.188"	R.188"	R.188"	R.188"		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.F.
Date:	28/09/03

Audited by:	LP
Date:	08/09/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 40 898
Description: 206 Saddle, Inboard, Left side	Part Number: D2668-1
Inspection Dwg: D2668 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2668 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120"	.120"				
B	0.100	0.140		.128"	.127"				
C	1.125	1.145		1.134"	1.134"				
D	0.615	0.685		.663"	.663"				
E	0.240	0.260		.252"	.252"				
F	1.313	1.343		1.323"	1.323"				
G	0.210	0.220		.221"	.221"				
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I	2.470	2.510		2.494"	2.494"				
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K	0.235	0.240		.237"	.237"				
L	0.100	0.120		.110"	.112"				
M	0.990	1.010		1.003"	1.001"				
N	0.510	0.515		.510"	.510"				
O	5.990	6.010		6.002"	6.002"				
P	1.245	1.255		1.250"	1.250"				
Q	2.495	2.505		2.502"	2.502"				
R	0.313	0.318		Ø.314"	Ø.314"				
S	0.315	0.322		Ø.320"	Ø.320"				
T	1.995	2.005		2.001"	2.001"				
U	1.357	1.367		1.364"	1.364"				
V	0.787	0.807		.804"	.801"				
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AB	0.178	0.198		R.188"	R.188"				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: J.F.
Date: 08/09/03

Audited by: RF
Date: 08/09/03

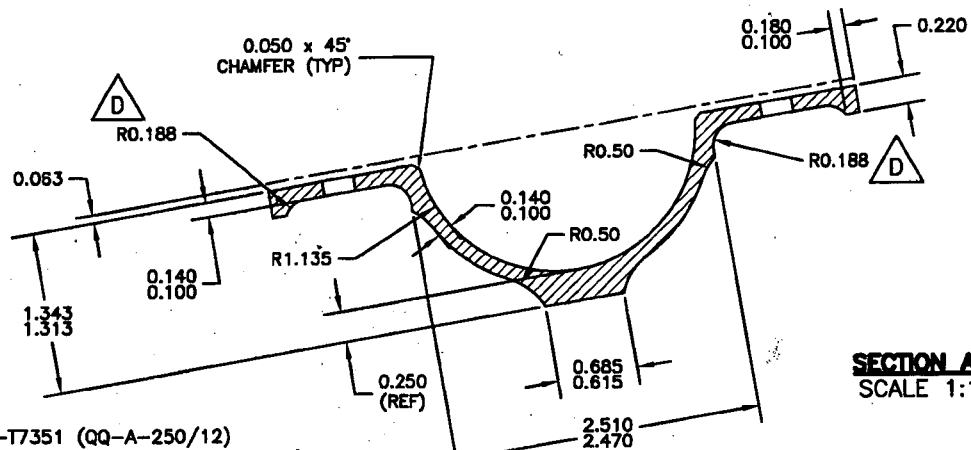
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

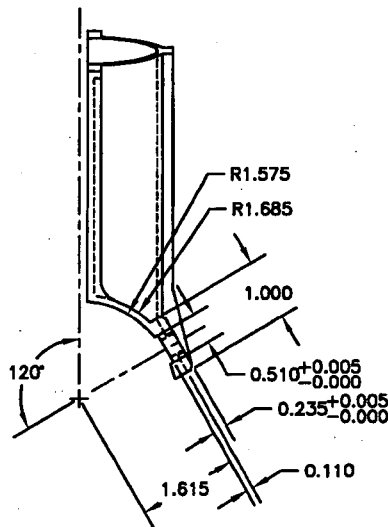
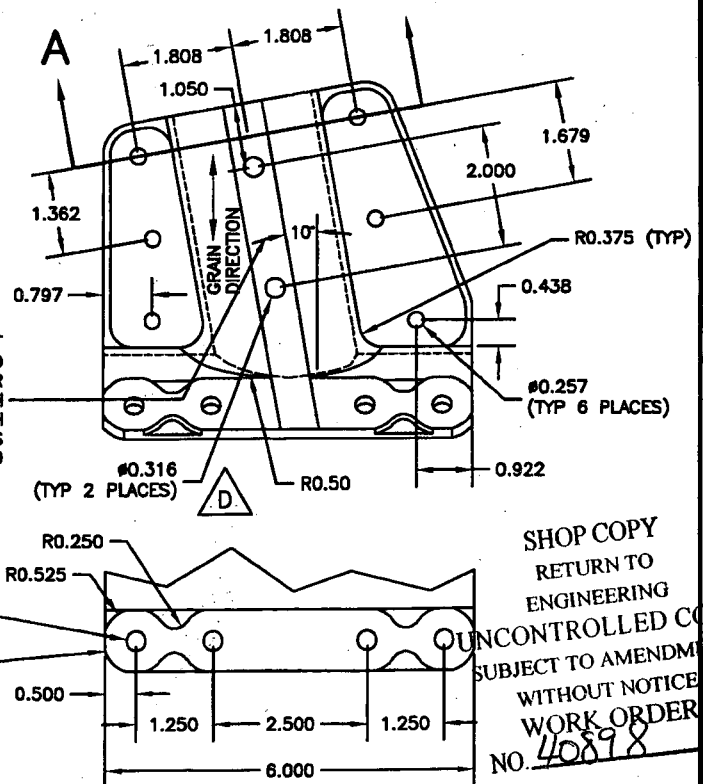
DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2668	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE AFT INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

RELEASED

07.02.12 #

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2668-1 SHOWN (D2668-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2668-1 SADDLE AFT INSIDE HIGH**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40898

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